

Ship Sept-20

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:11:37 AM
 User: Linda Lacelle

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STEP INSTALLATION RH (FOLDING) |
| Job Number : 28151 | |
| Estimate Number : 11451 | |
| P.O. Number : N/A | Part Number : D412630014 |
| This Issue : 15/08/2006 S.O. No. : N/A | Drawing Number : D2801 REV A1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LARGE FAB ASSY | Drawing Revision : A1 |
| Previous Run : 25705 | Material : N/A |
| Written By : _____ | Due Date : 20/09/2006 Qty: 7 Um: Each |
| Checked & Approved By : <u>W</u> | |
| Comment : Est Rev:E 04.05.17 Reformat; Removed AN3-16A KJ/RF | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



(7)

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-630-014 CHG004

KS 06 09.06

| | | |
|-----|-----------|-----------|
| 2.0 | D2622120C | Extrusion |
|-----|-----------|-----------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

327077

R.E. 06.07.15

7

7

Check Material for any Dents or Defects

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|

**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801

R.E. 06.07.15

7

2-Deburr and bevel ends for welding

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

R.E. 06.08.16 (7)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Part Number: D412630014

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| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------|-------------------|
| 5.0 | D2734 | 206 Step Endplate |
|-----|-------|-------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap 327281

LE 06.08.25 7

| | | |
|-----|--------|-----|
| 6.0 | D28022 | Arm |
|-----|--------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2802-2 Arm 328157

LE 06.08.25 7

| | | |
|-----|-------------|------------------------------|
| 7.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end caps as per Dwg D2801 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M400660

LE 06.08.28 2

2-Grind end cap welds flush as per Dwg D2801

LE 06.08.28 2

| | | |
|-----|-------|-----------------|
| 8.0 | QC5/9 | WELD INSPECTION |
|-----|-------|-----------------|



Comment: WELD INSPECTION

06.08.29 7
06/08/29

| | | |
|-----|-----------------|----------------------------|
| 9.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAP 06.08.31

(7) P10

| | | |
|------|----------------|----------------|
| 10.0 | POWDER COATING | POWDER COATING |
|------|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9-M 06.09.14

(7)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---------|------|--|----|---------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 06-09-6 | 9b. | debur & bevel aft. end for welding. | fl | 06-09-6 | | | |
| | 9c. | weld aft end cap as per diag 2801 and Q5E 004. | fl | 06-09-6 | | | |
| | 9d. | inspect for foreign objects as per Q5E 024 | fl | 06-09-6 | | | |
| | | aluminum rods # m100660 & m15689 | fl | 06-09-6 | | | |
| | 9e | grind aft end cap flush as per diag. 2801 | fl | 06-09-6 | | | |
| | 9f | weld inspection. Q5/9 | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DB Date: 06/09/22
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2801 and QSI 005 4.4

Batch: M101667

FC 06 07 15 (9)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAN 06:09:17 (7)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

14.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2012-107

Clevis B27 522

15.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2022-101 Spacer

B25 815

16.0

D2652

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D2652

Bushing B27108 27m4 B27145 1m4

17.0

D2803044

STA 84 Bracket Ass'y RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2803-044

Bracket Assembly B28157

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | |
|------|----------|--------------------------|
| 18.0 | D2804044 | STA 155 Bracket Ass'y RH |
|------|----------|--------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2804-044 Bracket Assembly B28161 6X B23354-2 1X

| | | |
|------|-------|--------------|
| 19.0 | D2807 | Support Prop |
|------|-------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2807 Gas Spring B27151

| | | |
|------|-------|--------|
| 20.0 | D2808 | Spacer |
|------|-------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2808 Bushing B27564

| | | |
|------|--------|-------|
| 21.0 | D28101 | Strut |
|------|--------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2810-1 Strut B25712

| | | |
|------|-------|--------|
| 22.0 | D2813 | Washer |
|------|-------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2813 Washer B25923

| | | |
|------|--------|------|
| 23.0 | AN320A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN3-20A Bolt M15432

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------|-----|
| 24.0 | AN3108 | Nut |
|------|--------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN310-8

Nut

M9634 9MLT
M101884

| | | |
|------|--------|------|
| 25.0 | AN410A | Bolt |
|------|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

QPick:

Qty Part Number

Description Batch

1 AN4-10A

Bolt

M17073

| | | |
|------|-------|------|
| 26.0 | AN816 | Bolt |
|------|-------|------|



fc Comment: Qty.: *2* 2.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN8-16

Bolt

M101291

M 102138 (4) X
M 102138 202

| | | |
|------|-----------|--------|
| 27.0 | AN960JD10 | Washer |
|------|-----------|--------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 35.0000 Each(s)

Pick:

Qty Part Number

Description Batch

5 AN960JD10

Washer

M100743

| | | |
|------|------------|--------|
| 28.0 | AN960JD416 | Washer |
|------|------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M19185

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 28151

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Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|------------|-------------------|
| 29.0 | AN960JD816 | 1/2" washer, Alum |
|------|------------|-------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 4 | AN960JD816 | Washer | M6956 |

| | | |
|------|-----------|-----|
| 30.0 | MS21042L3 | Nut |
|------|-----------|-----|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 35.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 5 | MS21042L3 | Nut (or -3) | M101390 |

| | | |
|------|-----------|-----|
| 31.0 | MS21042L4 | Nut |
|------|-----------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | MS21042L4 | Nut (or -4) | M19085 |

| | | |
|------|------------|-------------|
| 32.0 | MS24665285 | Cotter Pins |
|------|------------|-------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------------------------|
| 2 | MS24665-285 | Cotter Pin | B2421 (12) B 9003 (2) |

| | | |
|------|-------------|-------|
| 33.0 | MS24693S280 | Screw |
|------|-------------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|-------|
| 2 | MS24693-S280 | Screw | M8649 |

28

10.08

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|---------|-----------------------|---------------|

| | | |
|------|--------|------|
| 34.0 | AN316A | Bolt |
|------|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN3-16A

Bolt

M101884

06/2/18 (7)

| | | |
|------|-------------|-------------------------------|
| 35.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D412-630

SAD 06:09218 7

| | | |
|------|-----|------------------------------|
| 36.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/20 (7)

| | | |
|------|-------------|-----------------------|
| 37.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|------|----------|--------|
| 38.0 | D2012107 | Clevis |
|------|----------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2012-107

Clevis

027522

| | | |
|------|----------|--------|
| 39.0 | D2022101 | Spacer |
|------|----------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2022-101

Spacers

025815

| | | |
|------|--------|---------|
| 40.0 | D28061 | Bushing |
|------|--------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2806-1

Bushing

027285x1, 028162x13

DB 06/09/21

| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | |
|------|--------|---------|
| 41.0 | D28063 | Bushing |
|------|--------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2806-3 Bushing B28163

| | | |
|------|-------|------|
| 42.0 | AN46A | Bolt |
|------|-------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-6A Bolt M10K418

| | | |
|------|--------|------|
| 43.0 | AN410A | Bolt |
|------|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-10A Bolt M17073

| | | |
|------|--------|------|
| 44.0 | AN415A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-15A Bolt M102039

| | | |
|------|--------|------|
| 45.0 | AN515A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-15A Bolt M19278

DB06/09/21

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN960JD416 Washer 119185

47.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer 1101369

48.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) 119085

49.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) 1101648

2306/09/21

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-014

Location:

PPP Rev: B

2306/09/21 (7)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/09/22
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:11:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP INSTALLATION RH (FOLDING)

Job Number: 28151

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/22

Job Completion



U 2009.22

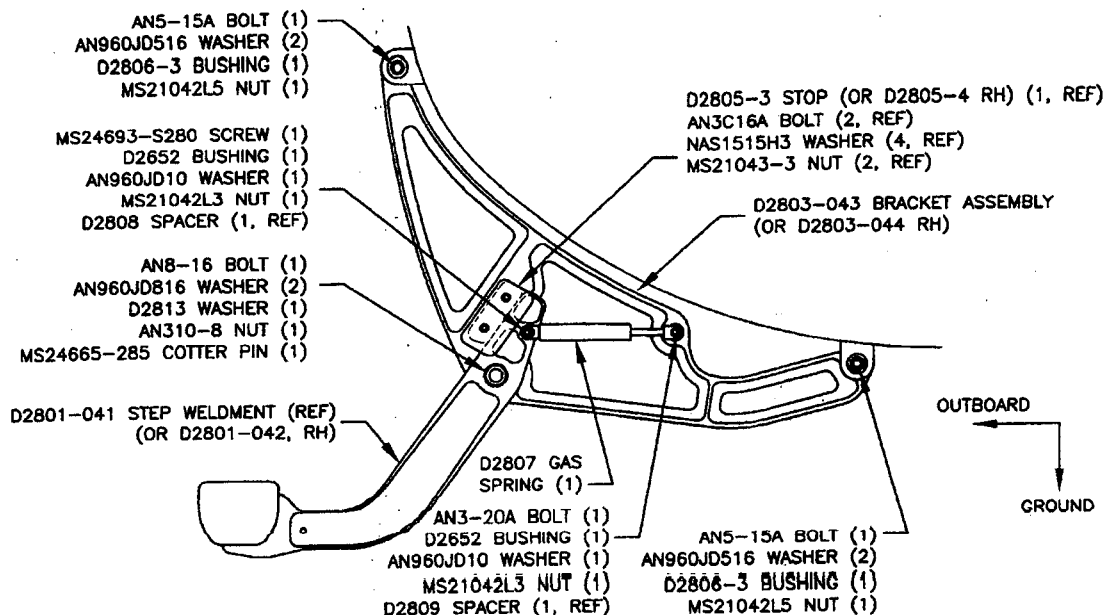
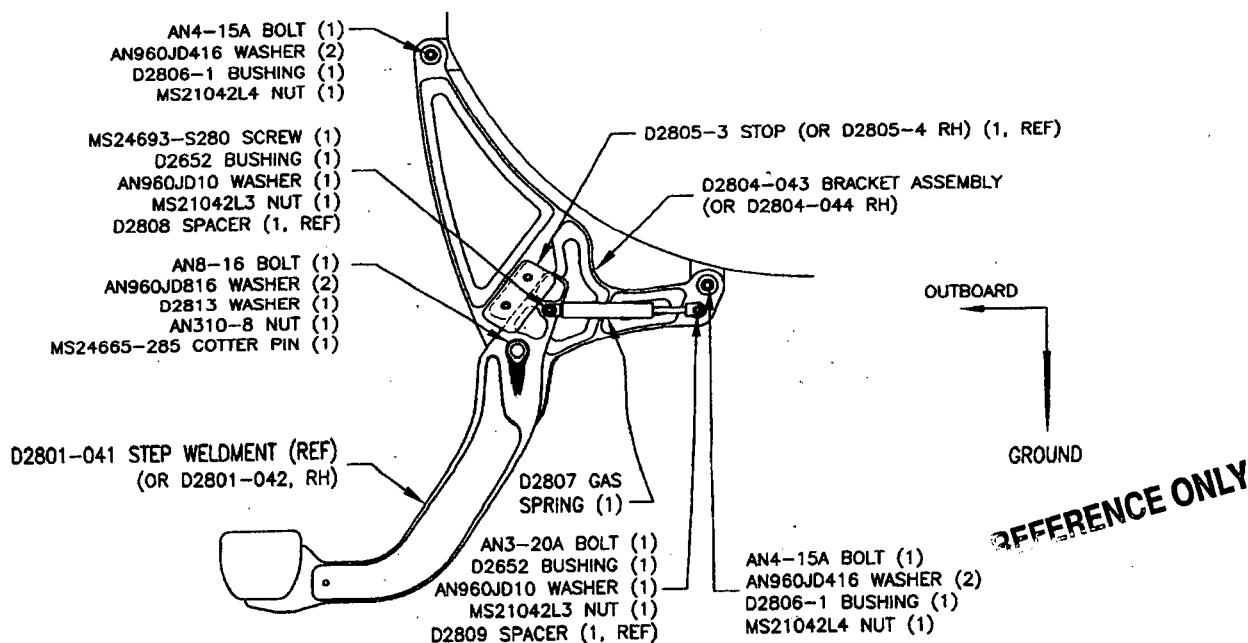
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

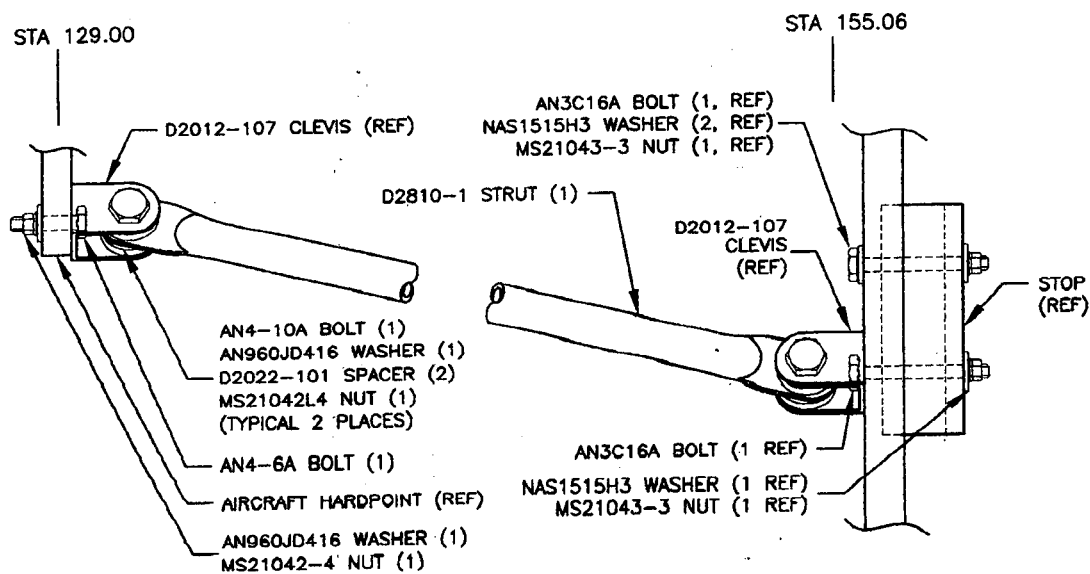
D412-630-013/-014 Heli-Access-Step™ Installation**FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: J
Date: 05.12.08

FIGURE 10 – Strut Detail for D412-630-013/-014 Heli-Access-Step™ Installation
(NOT TO SCALE)



REFERENCE

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Revision: J
Date: 05.12.08

38

Date: Tuesday, 15/08/2006 7:11:37 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28151
Estimate Number : 11451
P.O. Number :
This Issue : 15/08/2006 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : LARGE FAB ASSY
Previous Run : 25705
Written By :
Checked & Approved By :
Comment : Est Rev:E 04.05.17 Reformat; Removed AN3-16A KJ/RF

Drawing Name : STEP INSTALLATION RH (FOLDING)
Part Number : D412630014
Drawing Number : D2801 REV A1
Project Number : N/A
Drawing Revision : A1
Material :
Due Date : 20/09/2006 **Qty:** 7 **Um:** Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-630-014 CHG004

06.09.06 HJ

2.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

Check Material for any Dents or Defects

REFERENCE ONLY

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801

2-Deburr and bevel ends for welding

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP